Date: Monday, 4/23/2007 3:41:51 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number	: 32021		
Estimate Number	: 10831		
P.O. Number	: N/A	**Part Number**	: D29321
This Issue	: 4/23/2007 **S.O. No.** : N/A	**Drawing Number**	: D2932 REV C
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: C
Previous Run	: 31193	**Material**	: N/A
Written By	:	**Due Date**	: 5/15/2007 **Qty:** 8 **Um:** Each
Checked & Approved By	: 07.04.23		
Comment	: Est: B 00.06.26 New DWG rev, (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	7075-T7351 2X6.25X7.875

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
7075-T7351 2X6.25X7.875
Issue material from stock:
7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length
Batch No: B31387 J.L 07/07/15

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
5-Deburr & TUMBLE J.F. J.L 07/07/16 (8)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet J.L 07/07/17

4.0	QC1	INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET J.L 07/07/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** ☐ **Date:** 07/07/23

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:41:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 32021 **Part Number:** D29321

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	SC 07.07.17 (8)
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	DL 07-07-17 (8)
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	M 101575 BK/M.L 07-07-17 (8)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	7/7/18 (8)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	ST427 7/7/18 (8)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07.07.18

Job Completion 07.07.18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32021
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.109	.120	.120	.119		
B	0.100	0.140		.110	.119	.119	.117		
C	0.100	0.140		.115	.126	.124	.124		
D	0.210	0.230		.220	.221	.221	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.240	.239	.238	.238		
N	0.100	0.140		.114	.121	.119	.120		
O	0.540	0.560		.550	.550	.550	.549		
P	0.490	0.510		.501	.502	.500	.502		
Q	3.715	3.725		3.719	3.719	3.719	3.719		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.252	.250	.251	.250		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	.1636		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.135	1.137	1.133	1.135		
Y	1.565	1.585		1.573	1.574	1.571	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L
Date:	07/06/13

Audited by	
Date:	07.07.17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32021
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

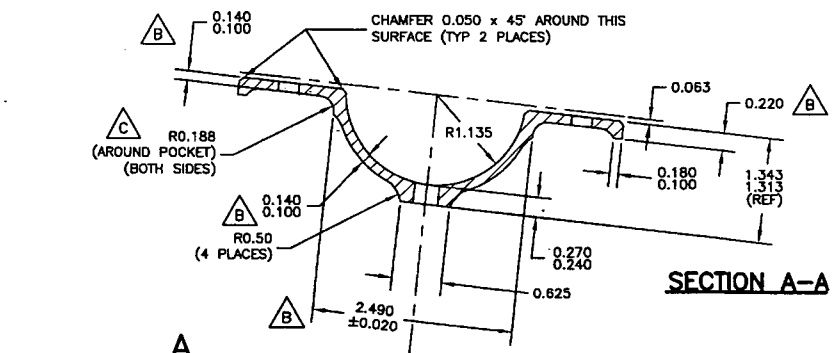
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.117	.119	.115"	.120"		
B	0.100	0.140		.117	.119	.115"	.117"		
C	0.100	0.140		.122	.122	.133"	.132"		
D	0.210	0.230		.220	.220	.224"	.226"		
E	1.245	1.255		1.250	1.250	1.252"	1.252"		
F	1.245	1.255		1.250	1.250	1.252"	1.252"		
G	2.495	2.505		2.500	2.500	2.499"	2.499"		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.577"	1.577"		
J	2.495	2.505		2.500	2.500	2.500"	2.500"		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.239	.240	.240	.238		
N	0.100	0.140		.120	.118	.121"	.121"		
O	0.540	0.560		.550	.549	.547"	.548"		
P	0.490	0.510		.499	.500	.503"	.505"		
Q	3.715	3.725		3.719	3.719	3.719"	3.719"		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.251	.251	.254"	.254"		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630"	1.630"		
V	1.362	1.372		1.367	1.367	1.367"	1.367"		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.135	1.135	1.133	1.133		
Y	1.565	1.585		1.573	1.572	1.572	1.571		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

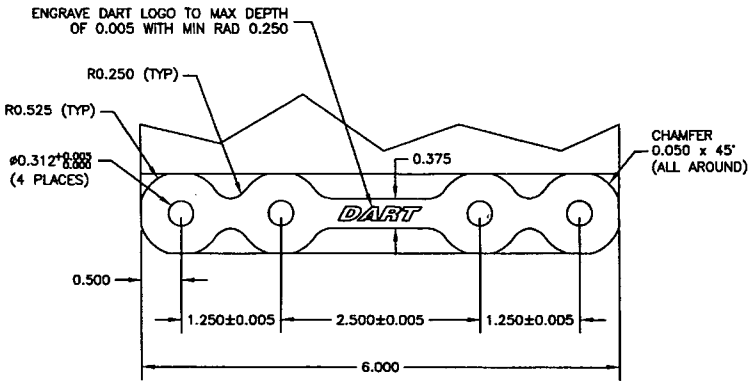
Measured by:	J.L / J.F.
Date:	07/04/13

Audited by	
Date:	07.07.17

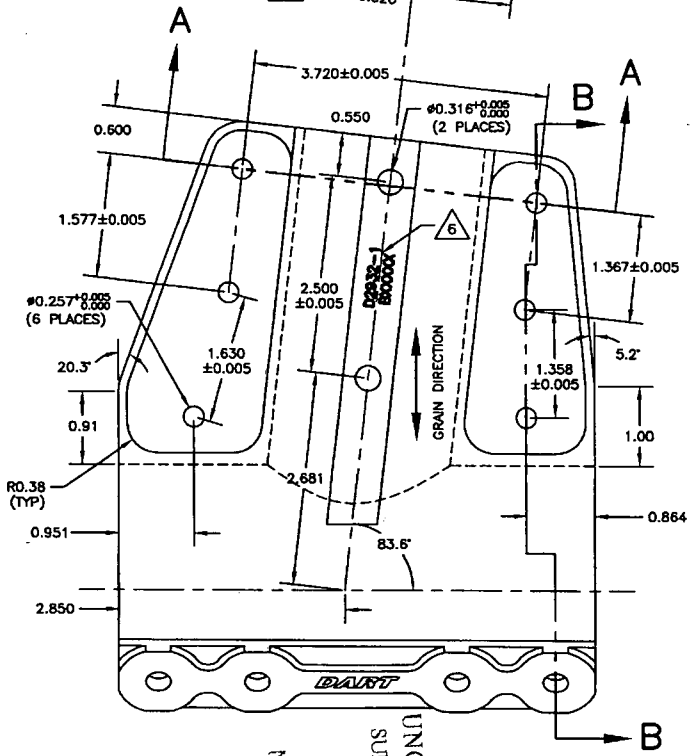
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



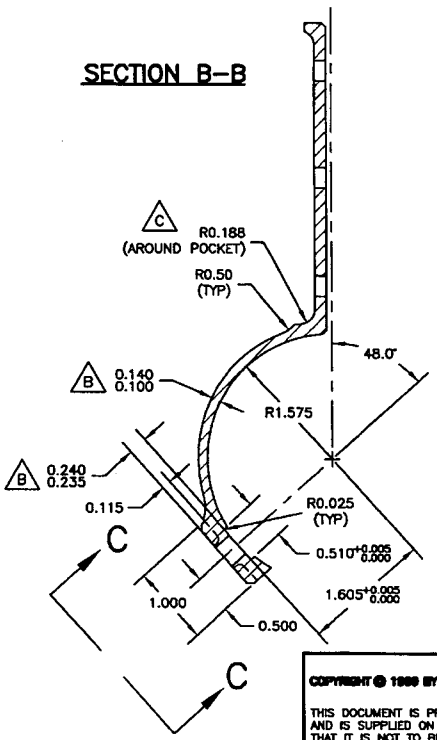
SECTION A–A



VIEW C–C



SECTION B–B



D2932–1 LH SADDLE (SHOWN)
D2932–2 RH SADDLE (OPPOSITE)

NOTES:
1) MATERIAL: ALUMINUM 7075–T7351 (QQ–A–250/12)
(MAKE FROM D6101–003 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2932	REV. C SHEET 1 OF 1
DATE 06.11.09		TITLE SADDLE OUTSIDE	SCALE 2:3